

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029854**Date Inspected:** 25-Jun-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 930**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1800**Contractor:** XKT/Nesco**Location:** XKT Engineering, Vallejo**CWI Name:** Wayne Van De Wark**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Saddle & Saddle fixture**Summary of Items Observed:**

Caltrans Quality Assurance Inspector (QAI) Monty Morris arrived at the XKT/Nesco facility for the purpose of witnessing fabrications of S1 & S2 Shear Key retrofit. The QC Manager was contacted by this QA regarding E2 Shear Key fabrications. The inspections performed were in accordance with Section 55 Steel Structures of the Standard Specifications and the project Special Provisions

This QAI witnessed the successful procedure qualification testing of the Nelson 3/8"x 3-3/16" headed shear studs to the 8" diameter sample pipe. The shear stud welding was performed and completed for the following 8" diameter schedule 40 pipe members and their respective quantities:

100A (1 total of 8 required); 100B (1 total of 8 required); 100C (1 total of 8 required); 100D (2 total of 8 required).

* Note that this welding needs an approved WPS for welding to this diameter.

WELDING INSPECTION REPORT

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Summary of Conversations:

There were general conversations with Quality Control personnel at the start of the shift regarding the location of the work and inspection personnel scheduled for this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By: Morris, Monty

Quality Assurance Inspector

Reviewed By: Foerder, Mike

QA Reviewer